

Work Order ID 151646

Wednesday, October 05, 2016 3:08:42 PM

151646

Page 1

Item ID: 646.3713 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Gusset
Start Date: 9/30/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 10/19/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: DAS Date: OCT 06 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

646.3700	A
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110

0.00

110

Waterjet

Memo

0.06

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.02

Quality Control

PR 16/10/07

12

PR 16/10/07

Work Order ID 151646

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151646

Page 2

Item ID: 646.3713

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gusset

Start Date: 9/30/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/19/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.04

Quality Control

(12)

DAS
38
9-89

OCT 11 2016

140

Bend as per dwg

0.03

140

Brake NC

Memo

0.08

Brake NC

DAS
30
9-89

(12)

OCT 11 2016

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.04

Quality Control

(12)

DAS
38
9-89

OCT 11 2016

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151646

Page 3

Item ID: 646.3713 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Gusset
Start Date: 9/30/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 10/19/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O to ATG : <u>34063</u> 1- Black Anodize as per Dwg 646.3700 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Comformity is required	0.00 359.99				<u>12</u>	<u>OCT 26 2016</u>		DAS 13 9-89
170 *170* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.04				<u>12</u>	<u>DAS 26 9-89</u>		NOV 11 2016
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.04				<u>12</u>			DAS 38 1-1-2016 NOV 11 2016

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151646

Page 4

Wednesday, October 05, 2016 3:08:42 PM

Item ID: 646.3713 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Gusset
Start Date: 9/30/2016 Start Qty: 12.00 *12* Cust Item ID:
Required Date: 10/19/2016 Req'd Qty: 12.00 *12* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>ack105</u>	0.00							
210									
Packaging	Memo	0.02							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.20							
Quality Control									

DAS
21
9-89

NOV 1 4 2016

Picklist Print

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Page 1

Work Order ID: 151646

151646

Parent Item: 646.3713

646 3713

Parent Item Name: Gusset

Start Date: 9/30/2016

Required Date: 10/19/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased			No	110	sf	222.1000	0.299	3.776842			

M6061T6S 063

6061-T6 .063 Sheet

PR 10/10/07

Location

Loc Qty

Loc Code

MAT021

222.1

M133511

2.6

M134377

3.3

M134830

216.2

~~4.7~~

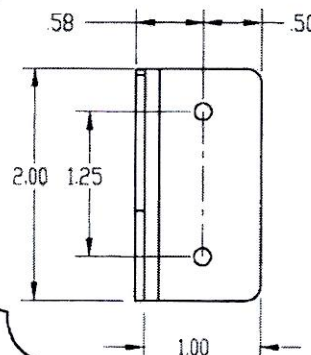
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03702				SHEET 1 OF 2	
	DWG NO. 646.3700	REV: A	PREPARED BY B. PETERS	DATE: 11/15/12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: SHEETMETAL					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: ADDED ALTERNATE MATERIAL AND REVISED REFERENCE DIMENSIONS				EOR: D-12-010	

SHEET 1, ZONE A2 IS:

IS

⚠ PRIMARY MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
ALTERNATE MATERIAL: SS 17-4 PH PER AMS 5604

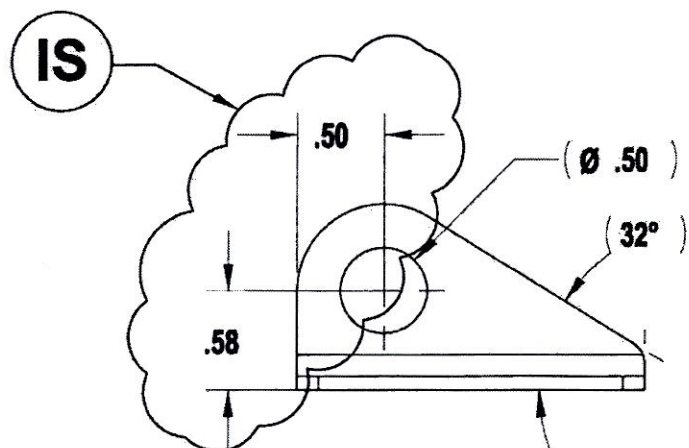
IS



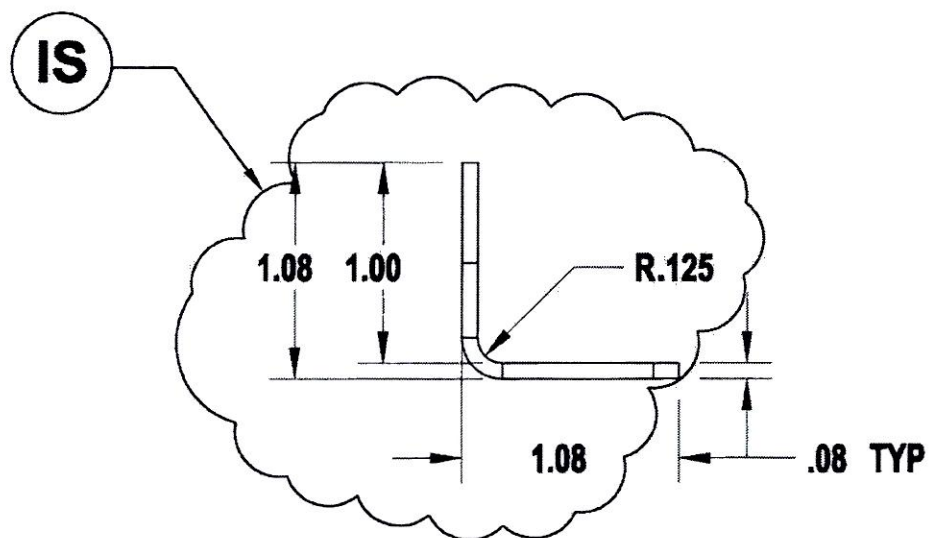
SHEET 7, ZONE B1 IS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151646 MWS
16-10-06

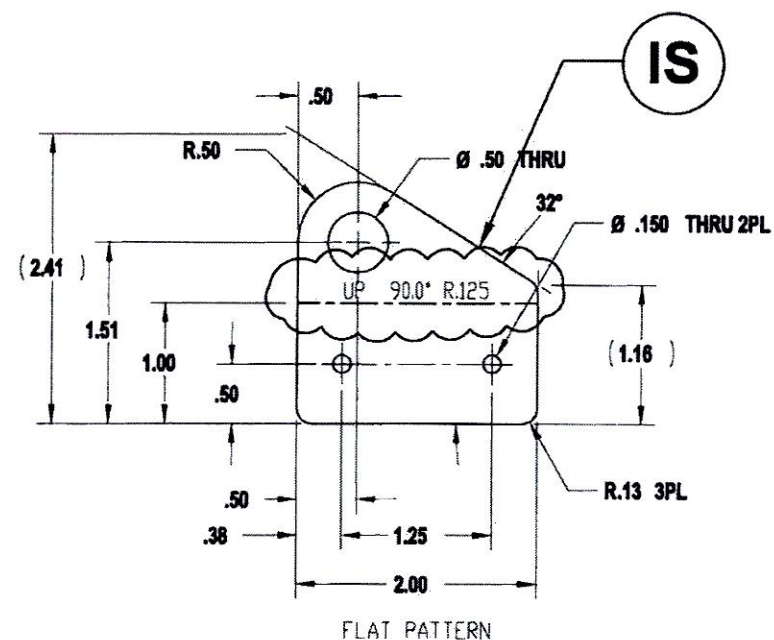
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				☐ RFMS ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO



SHEET 7, ZONE C4 IS:



SHEET 7, ZONE D1 IS:



SHEET 7, ZONE B7 IS:

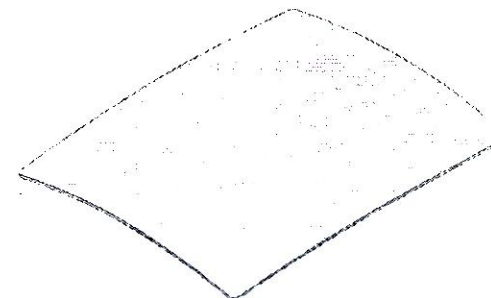
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
-----	----	-------------	-----	-------------	------------------------

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REV	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 02198	01/28/09	REV

NOTES:

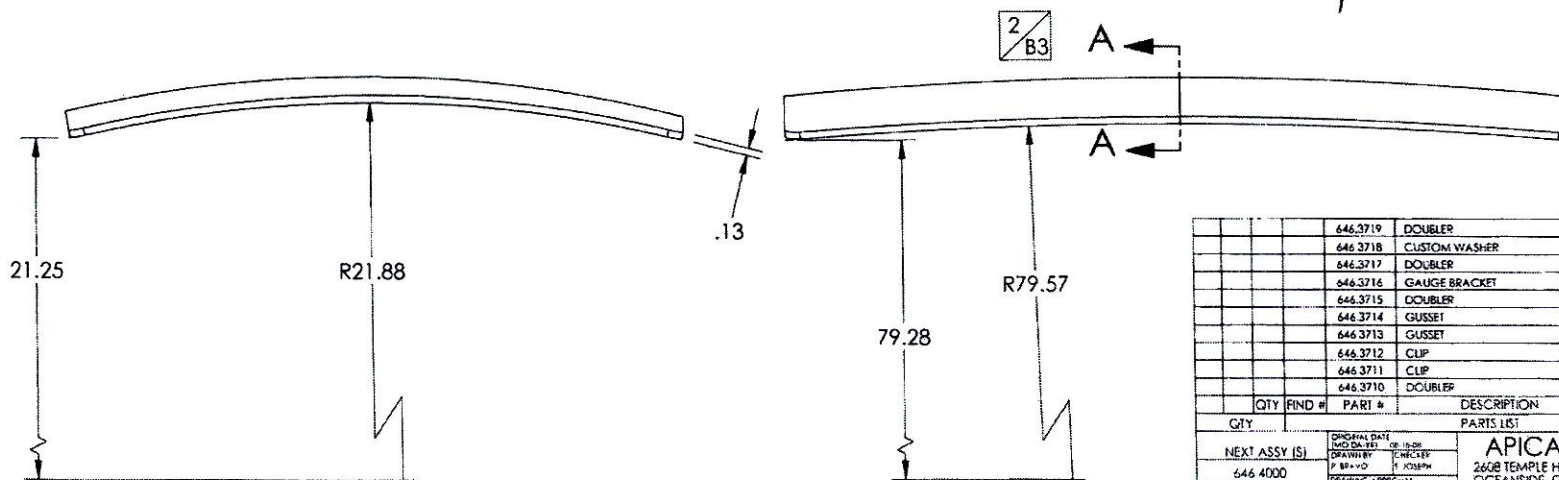
1. MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
3. MATERIAL: 17-4 PH AMS 5604, CONDITION H900
4. FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120



646.3710

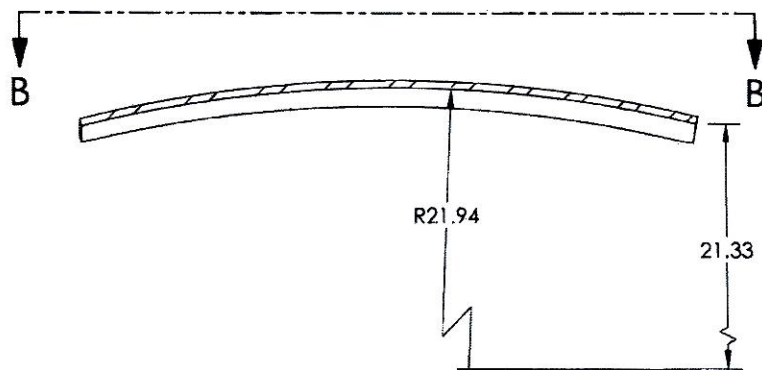
UNINCORPORATED ECN(s)

03702



		646.3719	DOUBLER						
		646.3718	CUSTOM WASHER						
		646.3717	DOUBLER						
		646.3716	GAUGE BRACKET						
		646.3715	DOUBLER						
		646.3714	GUSSET						
		646.3713	GUSSET						
		646.3712	CLIP						
		646.3711	CLIP						
		646.3710	DOUBLER						
		QTY	FIND #	PART #	DESCRIPTION			MAT'L	SPEC.
GTY					PARTS LIST				
NEXT ASSY (S)					APICAL INDUSTRIES				
646.4000					2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300				
ORIGINAL DATE					APICAL INDUSTRIES				
DRAWN BY: P. BRADY					2608 TEMPLE HEIGHTS DR.				
CHECKED BY: J. JOSEPH					OCEANSIDE, CA 92056-3512 (760) 724-5300				
DRAWING APPROVAL					SHEETMETAL				
DATE: 06-10-09					SEE CASE CODE				
UNLESS OTHERWISE SPECIFIED					B 07M26				
DIMENSIONS ARE IN INCHES					646.3700				
TOLERANCES ARE					SCALE: NONE				
FRACTIONS DECIMALS					SHEET 1 OF 9				
3 PLACE DECIMALS									
ANGLES ± 3°									

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SECTION A-A



R395.138

R.13 4PL

13.51

10.49

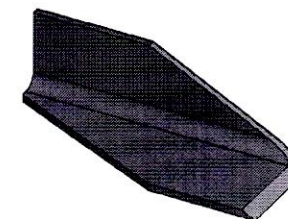
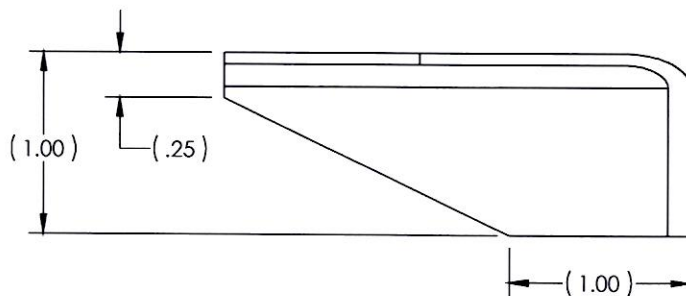
10.54

SECTION B-B

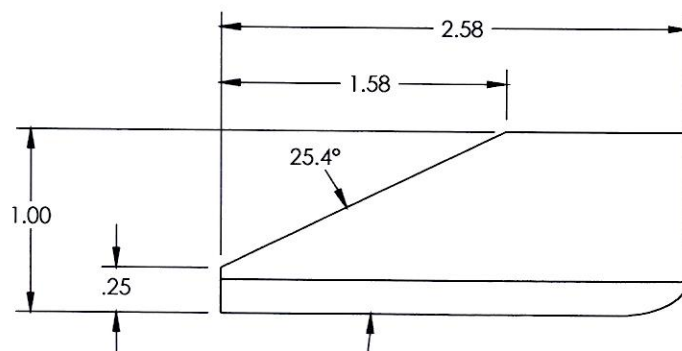
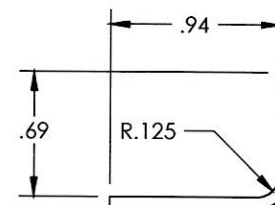
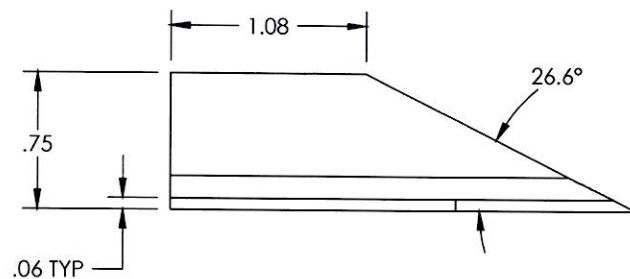
ORIGINAL DATE: 08.18.08 INCHES: 1/8"		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY: J. JOSEPH P. SPAYO		SHEETMETAL	
ENGINEER APPROVAL: J. JOSEPH 08.18.08		SET: 07M26 DWG NO: 646.3700	REV: A
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SCALE: NONE	SHEET 2 OF 9

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



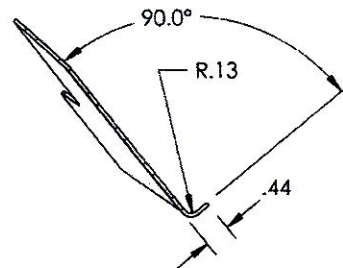
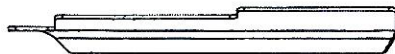
646.3711 SHOWN
646.3712 OPPOSITE



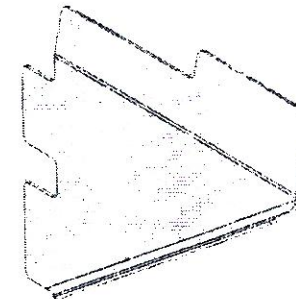
NEXT ASSY (S)	ORIGINAL DATE 08-18-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DRAWN BY P. BRAVO		
	CHECKED BY S. JOSEPH	SHEETMETAL	
	DRAWING APPROVAL T. JOSEPH		
	CONTRACT NO.		
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°	SIZE B	CAGE CODE 07M26
		DWG. NO. 646.3700	REV. A
		SCALE: NONE	SHEET 3 OF 9

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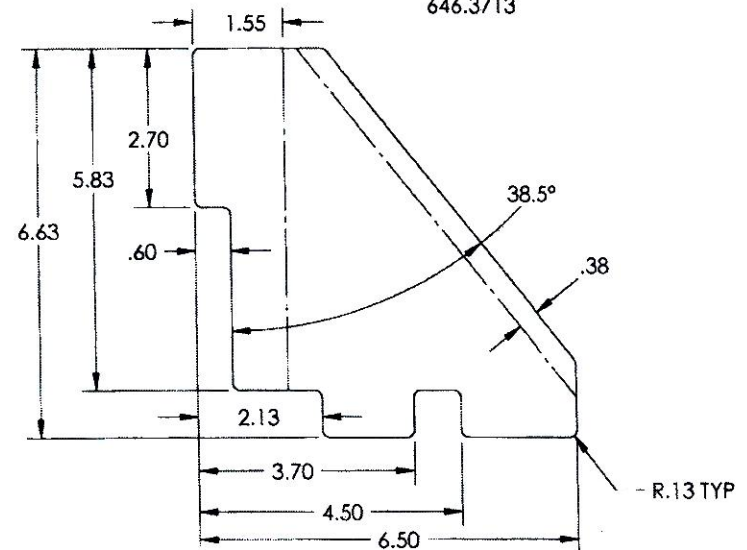
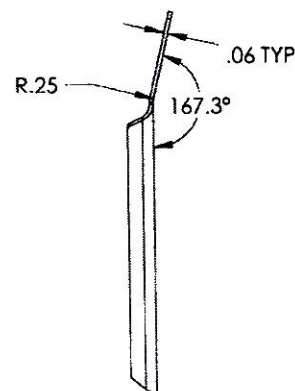
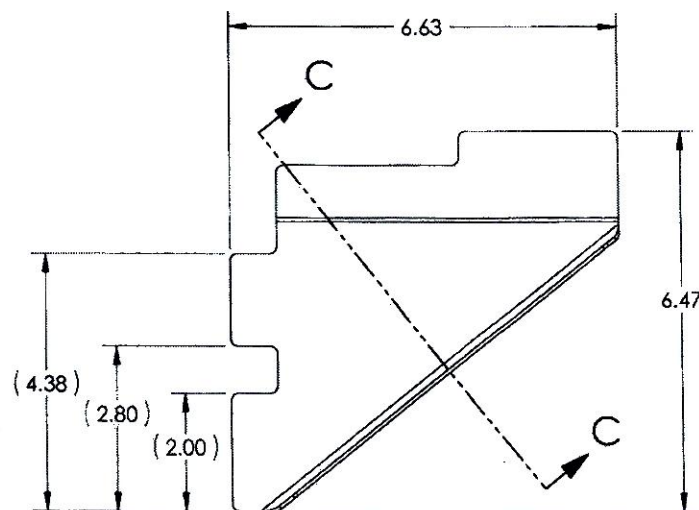
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



SECTION C-C



646.3713

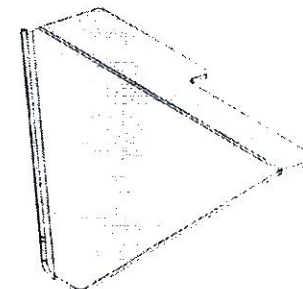
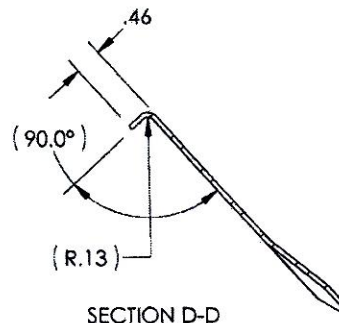
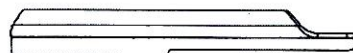


FLAT PATTERN

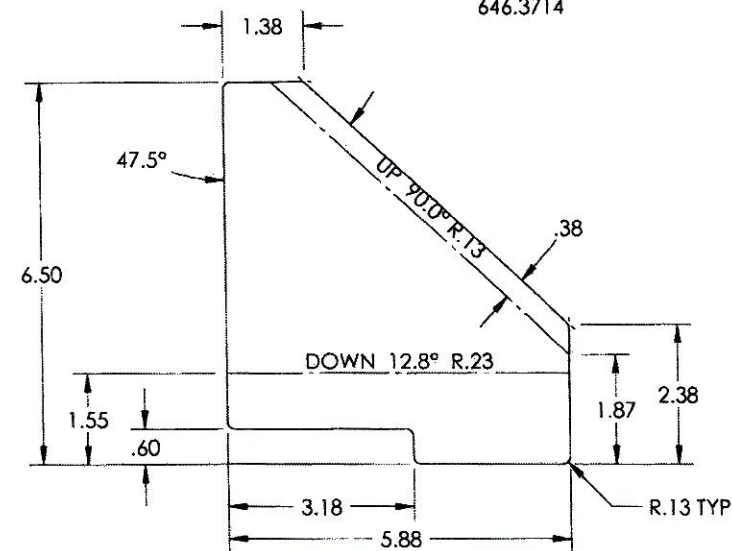
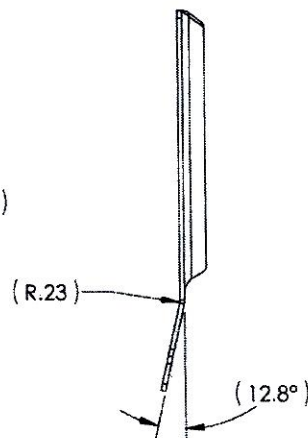
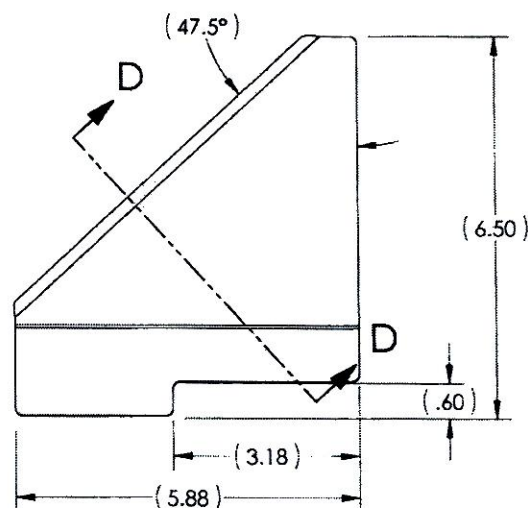
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	DESIGNED BY	ENGINEER		
	BY BRAYO	S. JOHNS	SHEETMETAL	
	DESIGNED APPROVAL	DATE		
			REV	
			8	07/02/06
			DWG NO	646.3700
			SCALE	1"=1"
			SHEET # OF 9	

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



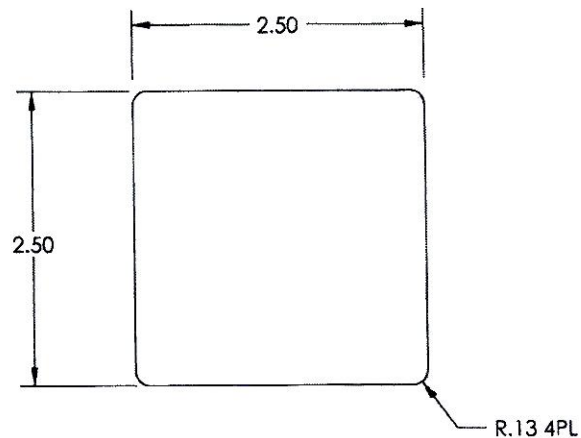
646.3714



DATE: 12-04-1988 DRAWN BY: S. JOHNSON P. BY: V.C. DRAWING APPROVAL: S. JOHNSON CHECKED: C. HEDGECOCK		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: FINISH DECIMALS ± .015 ANGLES ± 2°		SHEET METAL PART CODE: 646.3700 SCALE: NONE	PP: A SHEET 5 OF 9

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



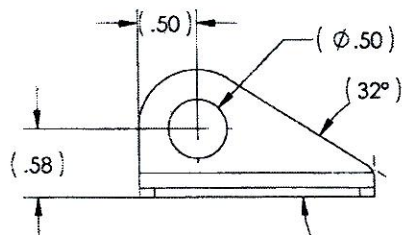
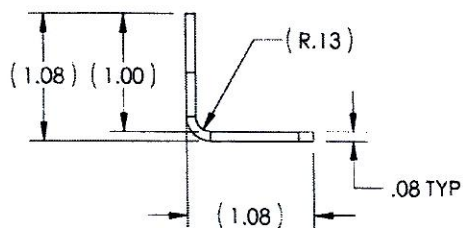
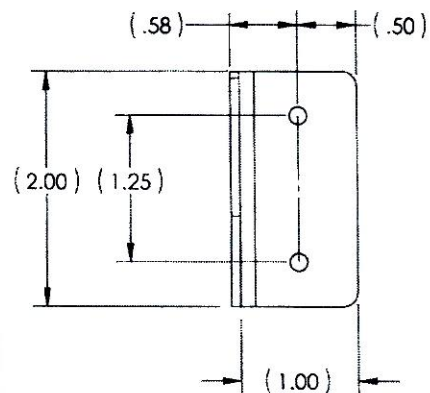
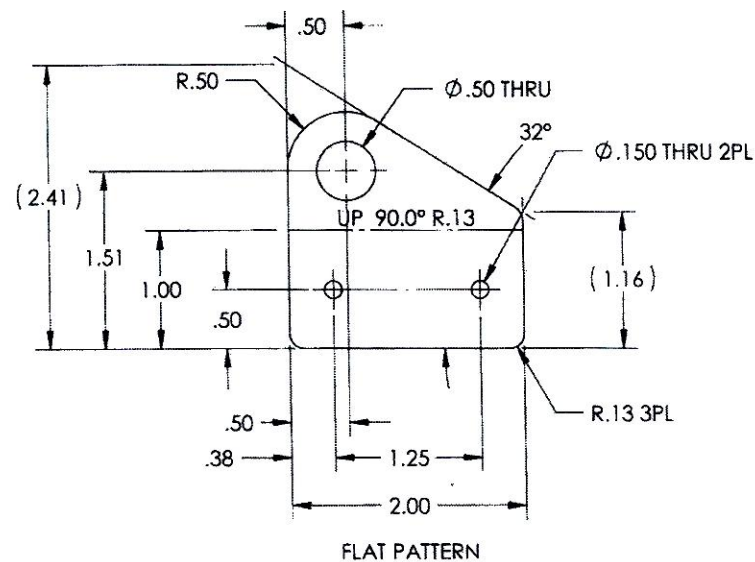
646.3715

NEXT ASSY (S)		ORIGINAL DATE 06-18-02		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
		DESIGNED BY P. BRAVO	CHECKED BY J. JOSEPH				
		DRAWING APPROVAL: J. JOSEPH					
		CONTRACT NO. 06-18-02					
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 3 PLACE DECIMALS ±.001 ANGLE: 3°		KIT CAGE CODE B 07A126	DWG. NO. 646.3700		
SCALE: NONE				SHEET 4 OF 7			

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

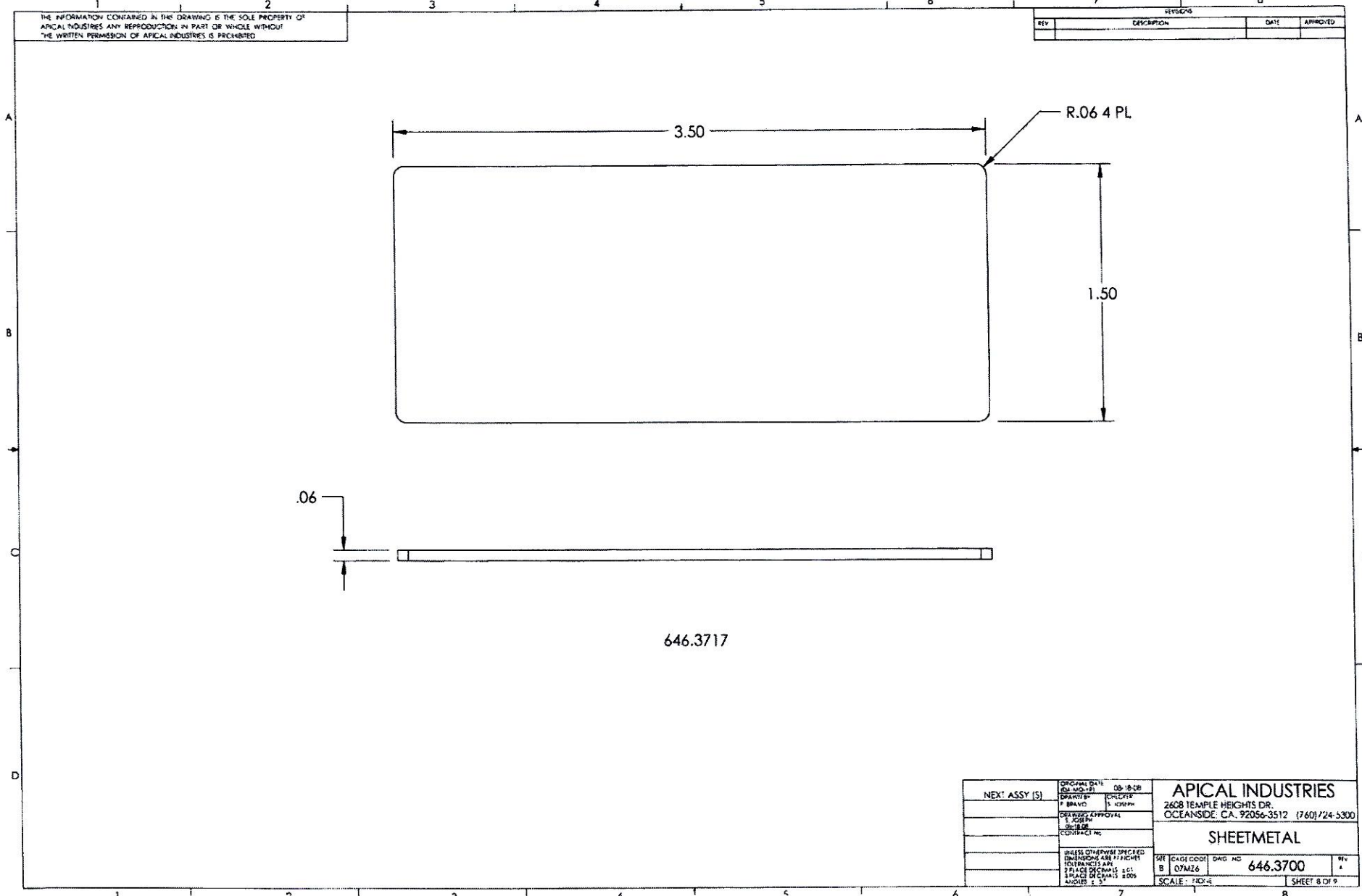
646.3716



NEXT ASSY IS:	ORIGINAL DATE	08-18-00	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR OCEANSIDE, CA. 92056-3512 (760)724-5300
	DRAWN BY	J. JOHNSON	
DRAWING APPROVED BY:	DRAWN BY	J. JOHNSON	SHEETMETAL
	CHECKED BY	J. JOHNSON	
CONTRACT NO.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ANGLES 1/16" ± 0.005 1/32" ± 0.005 1/64" ± 0.005 1/8" ± 0.005 1/4" ± 0.005 3/8" ± 0.005 1/2" ± 0.005 3/4" ± 0.005 1" ± 0.005 1 1/2" ± 0.005 2" ± 0.005 3" ± 0.005 4" ± 0.005 6" ± 0.005 8" ± 0.005 12" ± 0.005		DATE: 08-18-00 DWG NO: 646.3700
	SCALE: N/A		

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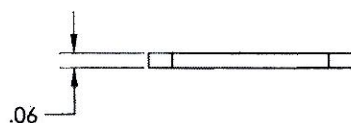
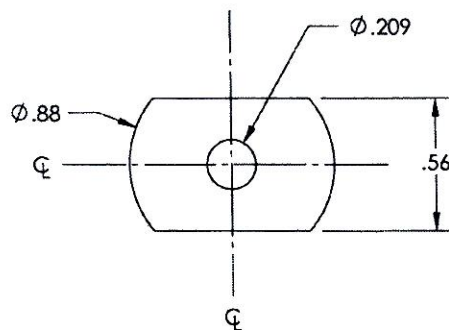
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



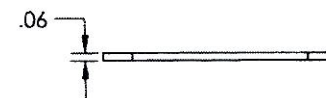
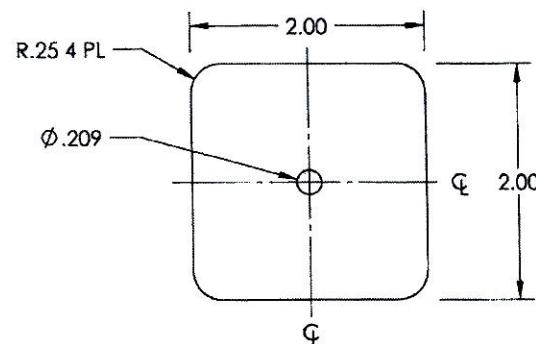
NEX: ASSY (S)	ORIGINAL DATE	08-18-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300
	DRAWN BY	CHUCKER	
	P. BRANCO	15-10-08	
	DESIGNER APPROVAL	15-10-08	
CONTRACT NO.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: SPACE DECIMALS .015 SPACE DECIMALS .005 ANGLES ± .5°		SHEET CODE	DWG. NO.
B		074126	646.3700
SCALE: 1:1		SHEET 8 OF 9	

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



646.3718



646.3719

NEXT ASSY IS:	OVERALL DATE	08-18-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 SHEETMETAL	
	DRAWN BY	J. JOSEPH		
	P. BRAYD	J. JOSEPH		
	DRAWING APPROVAL	J. JOSEPH		
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMAL: .001 2 PLACE DECIMAL: .005 ANGLES: 1/2°	
			NET (LAST CODE) B 07M12	DWD. NO. 646.3700
			SCALE: 1XNONE	SHEET 4 OF 4



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

Purchase Order ID PO34063

Purchase Order Date 10/26/2016
PO Print Date 10/27/2016

Page Number 4 of 9

Order From:

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To: DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613-446-4544

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

VENDOR'S TRUCK

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Total: \$67.10

9

151646

DAS
38
9-89

646.3713 GUSSET REV. A

11/9/2016
Yes
11/9/2016

12.00

DAS
26
9-89
NOV 11 2016 \$15.75

\$189.00

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS II

Line Total: \$189.00

10 151643

646.3714 GUSSET REV. A

11/9/2016
Yes
11/9/2016

12.00

\$15.75 \$189.00

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS II

Line Total: \$189.00

11 151477

646.3810 BRACKET
REV. N/C

11/9/2016
Yes
11/9/2016

10.00

\$6.55 \$65.50

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS II

Note:

10/27/2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912522

Date: 09-Nov-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
ea	Deflector Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20311 PO: 34063	Line: 4	
6 ea	Part: 646.2910 Deflector Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20312 PO: 34063	Rev: N/C Line: 5	
6 ea	Part: 646.3210 Support Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20313 PO: 34063	Rev: N/C Line: 6	
7 ea	Part: 646.3210 Support Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20314 PO: 34063	Rev: N/C Line: 7	
11 ea	Part: 646.3711 Clip Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20315 PO: 34063	Rev: A Line: 8	
12 ea	Part: 646.3713 Gusset Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20316 PO: 34063	Rev: A Line: 9	

DAS
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3-89

NOV 11 2016

DAS
26
9-89



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912522

Date: 09-Nov-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
Quantity	Description
	DATE : <u>9/11/16</u>
	CERTIFIED SIGNATURE : <u>DAS 26</u> <u>NOV 11 2016</u>
	RECEIVER SIGNATURE : <u>9-89</u>
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.
	CERTIFICATE OF CONFORMANCE
	A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.
	MADE IN CANADA.
	DAS 38 9-89